

Work Order ID 133110

Tuesday, May 26, 2015 12:44:34 PM

133110

Page 1

Item ID: D2344

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Deck Plate Aft

Start Date: 5/26/15 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJDate: MAY 26 2015

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2344

Rev F

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per dwg

prog rev: Fdwg rev: F

2-deburr as required

4 Ø Jm15-6-3

2024.063

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4 Ø Jm15-6-3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
05
9-89

15.6.3

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

1-Deburr sharp edges 2-Countersink holes per Dwg D2344

DAS
36
9-89DAS
05
9-89

15.6.4

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order ID 133110

Tuesday, May 26, 2015 12:44:34 PM

133110

Page 3

Item ID: D2344

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Deck Plate Aft

Stop ***NS2***

Start Date: 5/26/15

Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/26/15

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

(4) 15-06-04

155

QC7-Inspect Chemical Conversion Coat

0.00

155

QC

Memo

0.00

Quality Control

4 15-6-11 34 98

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:00

OVEN TEMPERATURE:

FINISH TIME:

10:30

4 15-6-11 34 98

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition			
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
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Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Work Order ID 133110

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Page 4

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N900040100

Setup Start

NS1

Revision ID:

Stop

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Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

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Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

DAS
38
9-89

JUN 11 2015

180

Identify as per dwg & Stock Location: S 200A

0.00

180

Packaging

Memo

0.00

Packaging

DAS
27
9-89

JUN 11 2015

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MCS

JUN 12 2015

MCS

JUN 12 2015

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Tuesday, May 26, 2015 12:44:33 PM

Page 1

Work Order ID: 133110

133110

Parent Item: D2344

D2344

Parent Item Name: Deck Plate Aft

Start Date: 5/26/15

Required Date: 5/26/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D00.06.26Removed P/O for powder coatEC
IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	177.6680	0.745	④			
M2024T3S 063										**		Jm15-6	
2024-T3 .063 sheet													

Location

Loc Qty

Loc Code

MAT022

177.668

m127866

15

m130525

162.668

130525

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART AEROSPACE LTD		Work Order: 133110
Description: Litter Deck Plate Kit (350)		Part Number: D2344
Inspection Dwg: D2344	Rev: F	Page 1 of 1

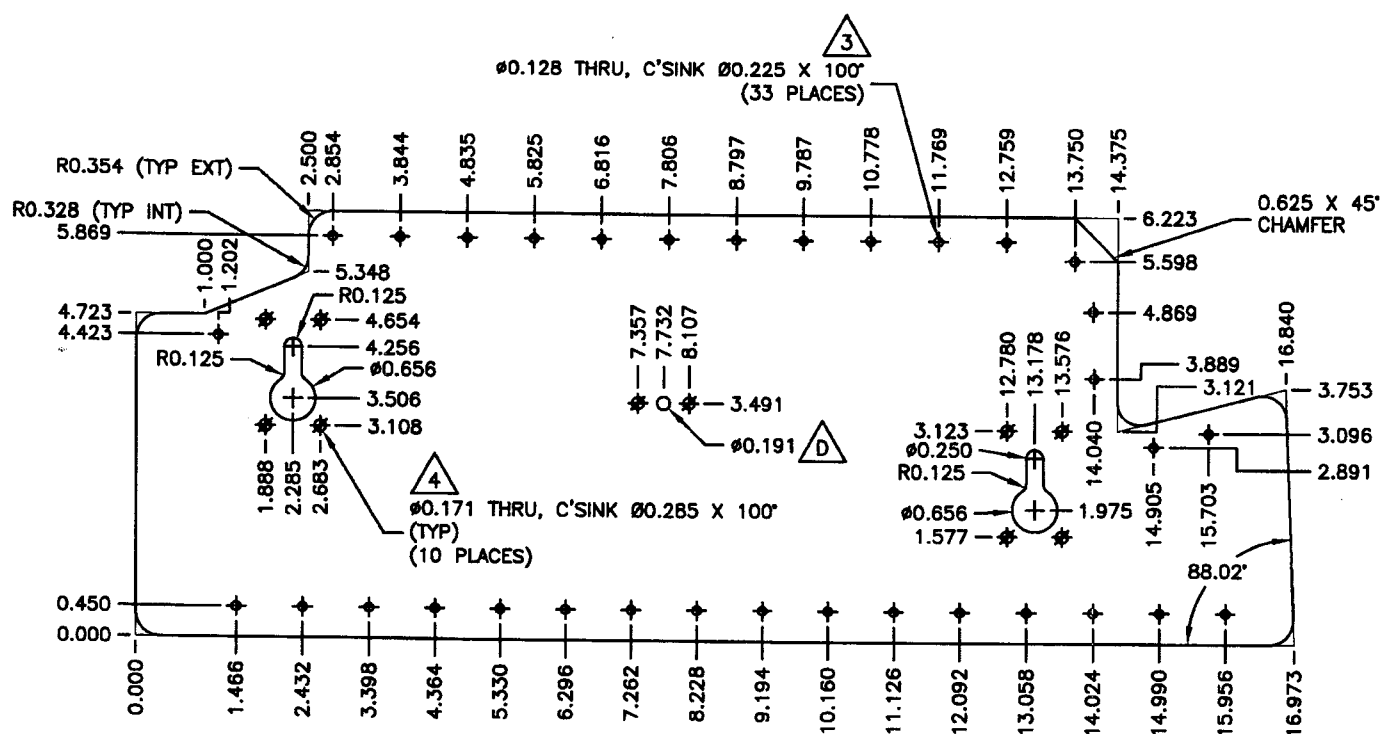
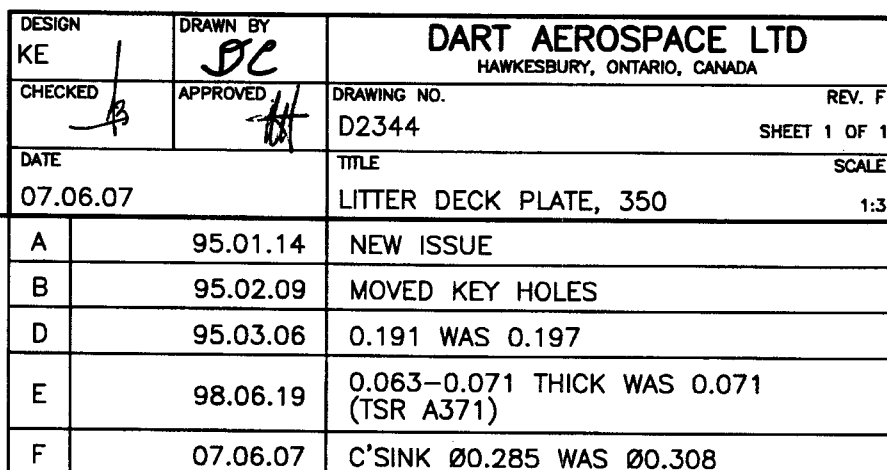
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.223	-		V	Jkmo1
5.598	+/-0.010	5.598	-		V	
4.869	+/-0.010	4.869	-		V	
3.889	+/-0.010	3.889	-		V	
3.096	+/-0.010	3.096	-		V	
2.891	+/-0.010	2.891	-		V	
16.973	+/-0.010	16.973	-		T	Jkmo7
0.450	+/-0.010	0.452	-		V	
4.423	+/-0.010	4.423	-		V	
4.723	+/-0.010	4.723	-		V	
1.202	+/-0.010	1.203	-		V	
5.869	+/-0.010	5.869	-		V	
4.654	+/-0.010	4.654	-		V	
Ø0.656	+0.005/-0.000	0.656	-		V	
1.888	+/-0.010	1.888	-		V	
2.285	+/-0.010	2.285	-		V	
2.683	+/-0.010	2.683	-		V	
Ø0.171	+0.005/-0.000	0.173	-		V	
3.491	+/-0.010	3.491	-		V	
Ø0.191	+0.005/-0.000	0.192	-		V	
3.123	+/-0.010	3.123	-		V	
1.975	+/-0.010	1.975	-		V	
Ø0.128	+0.005/-0.001	0.129	-		V	

Measured by: Jm	Audited by: 05 9-89	Prototype Approval:	N/A
Date: 15-6-3	Date: 15-6-3	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	



- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4
(REF. DART SPEC. M2024T3S)
- 2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) COUNTERSINK HOLES MARKED ∇ TO $\varnothing 0.225 \times 100^\circ$
- 4) COUNTERSINK HOLES MARKED ∇ TO $\varnothing 0.285 \times 100^\circ$
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

F

RELEASED

07.06.22

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